

VERSION WITH MARKINGS TO SHOW CHANGES MADE

(U.S. Patent No. 5,938,865)

IN THE CLAIMS:

The claims were **AMENDED** as follows:

1. (Amended) A process comprising steps of hot piercing and hot rolling for producing a high strength seamless steel pipe, having excellent sulfide stress cracking resistance, characterized by using [the] a billet of low alloy steel which contains, in weight %, 0.15-0.50 % of C, 0.1-1-1.5 % of Cr, 0.1-1.5 % of Mo, 0.005-0.50 % of Al, 0.005-0.50 % of Ti and 0.003-0.50 % of Nb, and comprising the followings steps [(1) to (5).]:

(1) hot piercing the billet into a hollow shell,

[(1)] (2) hot rolling the hollow shell with 40% or more of cross sectional reduction ratio,

(2) the hollow shell

[(2)] (3) finishing the hot rolling temperature range of 800-1100°C,

[(3)] (4) putting the manufactured steel pipe promptly in a complementarity heating apparatus after the finish rolling, and complementary heating at the temperature and time satisfying the following formula (a)[.],

[(4)] (5) quenching the steel pipe immediately after taking out of the complementary heating apparatus, and

[(5)] (6) tempering the pipe at a temperature not higher than the Ac₁ transformation point as the last heat treatment[.],

$$23500 \leq (T + 273) \times (21 + \log t) \leq 2600 \text{ ---- (a)}$$

where, T (°C) is a temperature of not lower than 850°C, and t is a time (hr).

2. (Amended) A process for producing a high strength seamless steel pipe, having excellent sulfide stress cracking resistance according to claim 1, characterized by further comprising one or more times intermediate heat treating which consists of quenching or combination of quenching and tempering, between the above-mentioned quenching [(4)] step (5) and the last heat treatment [(5)] step 6.